



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

Tel (613) 632-5200
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D5549-1

Job Sheet 194981



Part No: D5549-1

Job Qty: 1 pcs

Part Name: Fwd Beam



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/13/19

Job Tracking No:

Due Date: 6/14/19

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG D5549 REV.B SHEETS 5, 6 IPP REV:A 17.09.01 NEW ISSUE DD VERF:DP IPP REV:B 18.01.17 AS
PER DWG REV.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	1 pcs		6/14/19	0.00	2.18	Waterjet - Flow		2/19/05/05
110	QC 2	1 pcs		6/14/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		2/19/05/05
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		
							QC 2 - 5		
							QC 2 - 71		
120	HAAS 4 Axis - B4B	1 pcs		6/14/19	0.00	1.68	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 2	1 pcs		6/14/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		

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					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
140	QC 8	1	6/14/19	0.00 0.00	QC 8 - 12	
	pcs				QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
150	Handfinish - 1-1 Chemical-B4B	1	6/14/19	0.00 0.49	Handfinish - 1 - 1 - B4B	
	pcs				Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	

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Amk 19/06/05

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					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
					QC 7 - 10	
160 QC 7	1 pcs	6/14/19	0.00 0.00		QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
170 Powdercoat - 1 White Gl(A)-B4B	1 pcs	6/14/19	0.00 0.11		Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
180 QC 3	1 pcs	6/14/19	0.00 0.00		QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	

BK 19-6-7.

BK 19-6-7.

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190 Packaging 3-1 - Stock - B4B	1 pcs	6/14/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	DAS
				Packaging 3 - 7 - B4B	58 JUN 10 2019
				Packaging 3 - 8 - B4B	9.89
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
200 QC 21 - SA	1 pcs	6/14/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21 JUN 10 2019
				QC 21 - SA - 53	9.89

Part Op 100 - 1-Cut contour and pockets as per Dwg Dwg Rev: B Prog Rev: B 2-Deburr if necessary

Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)

120 - (HAAS CNC Vertical Machine), Drill holes as per dwg manually on Hass4 Dwg rev: _____

130 - (QC2- Inspect parts off machine FAI/FAIB)

140 - (QC8- Inspect parts - second check)

150 - (Chemical Conversion Coat per QSI005 4.1)

160 - (QC7-Inspect Chemical Conversion Coat)

170 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3 Alum), ***Mask holes or blow out access powdercoat in holes*** START TIME: 8:30 OVEN TEMPERATURE: 320 FINISH TIME: 8:50 11/75/51

180 - (QC3- Inspect Part Finish)

190 - (Identify as per dwg & Stock Location: _____)

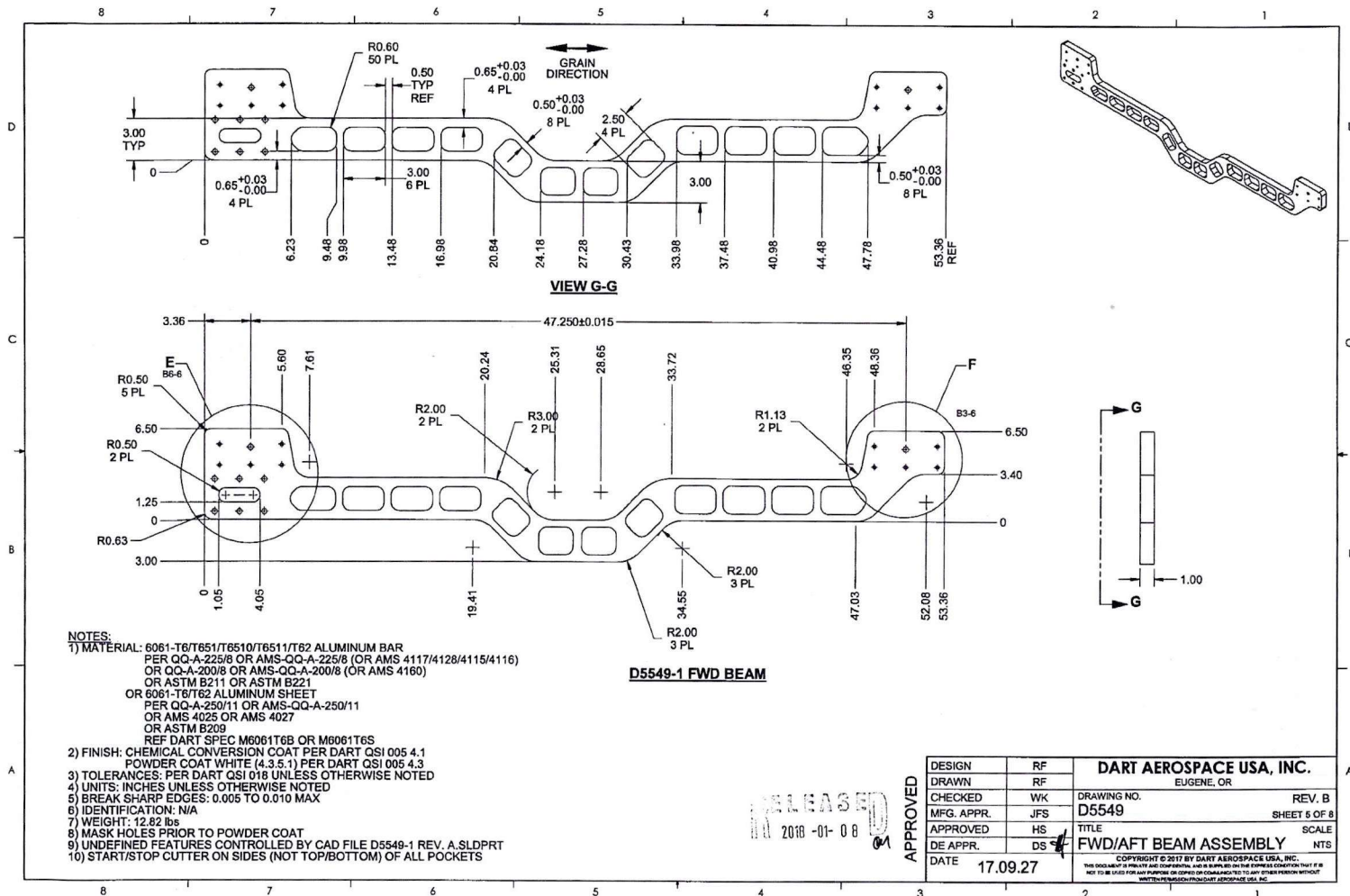
200 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X12.000	6061-T6 Bar 1.00 X 12.00	4.6000 ft (4.6 ea)	100-Waterjet - Flow - 1	S123956

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6B1.000X12.000	5	15	0

Part Specifications	
Specifications could not be found.	

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Container No: S184129



Part: D5549-1

Job No: 194981

Serial No/Batch: S184129

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 05/27/19

DART AEROSPACE LTD		Work Order: 194981
Description: D5549-1		Part Number:
Inspection Dwg: D5549 Rev: B		Page 1 of 1

INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
CNC						
.50	- .000 + .030	.526	1		V-DL-02	
.50	- .000 + .030	.530	1		Top	
2.50	+/- .030	2.47	1			
.50	+/- .030	.522	1			
3.00	+/- .030	3.022	1			
6.23	+/- .030	6.23	1			
9.48	+/- .030	9.48	1			
9.98	+/- .030	9.98	1			
13.48	+/- .030	13.48	1			
16.98	+/- .030	16.98	1			
20.84	+/- .030	20.84	1			
24.18	+/- .030	24.18	1			
27.28	+/- .030	27.28	1			
30.43	+/- .030	30.43	1			
33.98	+/- .030	33.98	1			
Manual Milling						
37.48	+/- .030	37.48	1			
40.98	+/- .030	40.98	1			
44.48	+/- .030	44.48	1			
47.76	+/- .030	47.78	1			
1.05	+/- .030	1.075	1			
6.50	+/- .030	6.528	1			

Measured by: DL	Audited by: [Signature]	Preliminary Approval:
Date: 19/05/25	Date: 19/06/05	Date:

Rev	Date	Change	Revised by	Approved
A	14.07.14	New Issue	KJ	

